

Work Order ID 87030

87030

Page 1

July-10-12 7:13:15 AM

Item ID: K10112

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Skidtube 206

Start Date: 7/10/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/12/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9583	A
K10112	C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP
FOR D206-642-112 CHG007
FOR D206-642-114 CHG002

K10112 CHG003

JB S12/12/10

MLJ 12/07/10

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1

12/07/10 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87030

July-10-12 7:13:15 AM

87030

Page 2

Item ID: K10112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 7/10/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/12/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120		0.00		8/2/14					
QC	Memo								
Quality Control									
130	Packaging	0.00							
130		0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP K10112								
	PPP D206-642-111								
	PPP D206-642-113								
	Location: <u>A</u>								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

Handwritten signature

PPP 87028

MLJ 12/07/12
MLJ 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:13 AM

Page 1

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206







Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F 11.09.23 PER REV.B DD
VERF:EC IPP REV:G 11.11.14 AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 CHL7001		Manufactured	No			110	Each	18.0000		1	73		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG120		5							
				79558		5							
				FG125		13							
				83042		9			83042				
				85507		4							
		Manufactured	No			110	Each	195.0000		16	20		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		44							
				31985		44							
				ST013		151							
				73836		36							
				81951		61							
				83744		54			83744				
		Manufactured	No			110	Each	46.0000		1	12/07/10		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST420		4							
				79233		4							
				ST464		42							
				80224		4							
				83307		18			83307				
				83867		20							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:13 AM

Page 2

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

D2661-2
Saddle, RH Ewd-Aft Out 206

Manufactured No

110 Each 10.0000

2 2 *vg* *L*

Location	Loc Qty	Loc Code
MEZZ	6	
10015	1	
10016	1	
10476	3	
9913	1	
ST434	4	
79201	2	
79203	2	

D2662-2
Saddle, RH In 206

Manufactured No

110 Each 31.0000

2 2 *vg* *L*

Location	Loc Qty	Loc Code
Mezz	2	
11028	4	
9042	3	
9043	2	
ST434	22	
80992	20	
83491	2	

D2712
Set Screw

Manufactured No

110 Each 631.0000

10 10 *vg* *12/07/10* *W*

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST017	581	
81871	81	
83559	250	
84433	250	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:13 AM

Page 3

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

D2884 Saddle Spacer . Manufactured No 110 Each 61.0000 **2** 2 *JB*

Location	Loc Qty	Loc Code
FG	10	
29453	10	
ST020	51	
76751	51	

D2885 Saddle Spacer Manufactured No 110 Each 52.0000 **2** 2 *JB*

Location	Loc Qty	Loc Code
FG	10	
29199	10	
ST020	42	
76752	42	

AN3-41A Bolt Purchased No 110 Each 313.0000 **8** 8 *JB*

Location	Loc Qty	Loc Code
ST354	313	
121162	113	
121243	200	

AN4C5A BOLT Purchased No 110 Each 172.0000 **0** 1 *JB*

Location	Loc Qty	Loc Code
ST355	172	
112243	135	
119017	37	

AN4-6A Bolt Purchased No 110 Each 1,375.0000 **12** 12 *JB 12/07/10*

Location	Loc Qty	Loc Code
ST356	1375	
119017	375	
121243	500	
122151	500	

July-10-12 7:13:14 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:14 AM

Page 4

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Bolt	Purchased	No	110	Each	473.0000	4	4	✓ JB	C
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST337	473					
			118191	80					
			121243	100					
			122151	293					
AN6-11A Bolt	Purchased	No	110	Each	416.0000	4	4	✓ JB	C
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST337	416					
			118191	13					
			119512	403					
AN6-44A Bolt	Purchased	No	110	Each	47.0000	2	2	✓ JB	C
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST343	7					
			119127	7					
			st510	40					
			119036	40					
NASH149D0363J Washer	Purchased	No	110	Each	1,142.0000	8	8	✓ JB 12/07/10	C
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST298	1142					
			116025	1					
			117601	61					
			118612	3					
			119537	33					
			120142	13					
			120308	17					
			121243	326					
			121524	688					

July-10-12 7:13:14 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:14 AM

Page 5

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

~~NASH149D0463J~~
Washer

Purchased No

110 Each 2,066.0000

24

24

JB

Location

Loc Qty

Loc Code

ST298

89

104746

3

116805

0

119097

27

121255

48

121708

11

ST299

1974

121912

1974

ST351

3

121912

107321

3

~~NASH149D0563J~~
Washer

Purchased No

110 Each 2,821.0000

8

8

JB

Location

Loc Qty

Loc Code

ST298

2821

119546

821

119546

121255

2000

~~NASH149D0663J~~
Washer

Purchased No

110 Each 610.0000

4

4

JB

12/07/10

Location

Loc Qty

Loc Code

ST298

610

121243

8

121444

102

121444

121708

500

July-10-12 7:13:14 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:15 AM

Page 6

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Nut

Purchased

No

110

Each

3,306.0000

8

Location

Loc Qty

Loc Code

ST300

1306

117885

32

119017

771

119075

138

121444

365

ST317

2000

122141

2000

MS21042L4

Nut

Purchased

No

110

Each

1,299.0000

12

Location

Loc Qty

Loc Code

ST300

1299

119075

116

121011

193

121444

786

121652

204

MS21042L6

Nut

Purchased

No

110

Each

491.0000

2

Location

Loc Qty

Loc Code

ST300

491

117677

25

118384

3

118927

48

119075

215

120308

200

July-10-12 7:13:15 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 7:13:15 AM

Page 7

Work Order ID: 87030

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 7/10/12

Required Date: 7/12/12

Start Qty: 1.00

Required Qty: 1.00

NASH149G0463R

Washer

Purchased

No

110

Each

768.0000

1

1

JB 12/07/10

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

767

117735

17

119097

750

119097

July-10-12 7:13:15 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-2	2	2	2
5	D2662-2	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	K10112	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	